

Work Order ID 76477

Tuesday, November 15, 2011 12:18:18 PM

76477

Ship Friday Nov 18th Page 1

Item ID: D3779-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Handle Assembly (Exterior)

Stop ***NS2***

Start Date: 11/15/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/15/2011 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

MF

Date: 11-11-15

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3779 | Rev A | | | | | | | | |
| 100 | FLOW WATER JET | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| Waterjet | Memo | 0.00 | | | | | | | |
| FLOW CNC Waterjet | 1-Cut as per Dwg D3779 Dwg Rev: _____ Prog Rev: _____ 2-Deburr if necessary | | | | | | | | |
| 110 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 120 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

MF 11-11-15

Work Order ID 76477***76477***

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Tuesday, November 15, 2011 12:18:18 PM

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Start Date: 11/15/2011 Start Qty: 2.00

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Required Date: 11/15/2011 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Small Fab

Small Fab

Memo

0.00

Small Fab

1- counter sink holes as per dwg D3779
2- deburrME
11-11-15

140

0.00

140

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

150

0.00

150

Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

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Tuesday, November 15, 2011 12:18:18 PM

Item ID: D3779-041

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Stop ***NS2***

Item Name: Handle Assembly (Exterior)

Start Date: 11/15/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/15/2011 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

160

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

180

180

Small Fab

Small Fab

Small Fab

Memo

0.00

0.00

1- rivet D3203-1 handle to D3779-1 plate as per dwg D3779 per QSI003

190

190

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

(2)

(2)

Work Order ID 76477***76477***

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Tuesday, November 15, 2011 12:18:18 PM

Item ID: D3779-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Handle Assembly (Exterior)

Start Date: 11/15/2011 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 11/15/2011 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 200 | Identify as per dwg & Stock Location: <u>81</u> | 0.00 | | | | | | | |
| *200* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 210 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *210* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

11/11/18 51 (2)

11/11/18 91

11/11/18
(2)

Picklist Print

Tuesday, November 15, 2011 12:18:17 PM

Page 1

Work Order ID: 76477

Parent Item: D3779-041

Parent Item Name: Handle Assembly (Exterior)

Start Date: 11/15/2011

Required Date: 11/15/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-06-09 new issue DD verified by:ec
IPP Rev:B 08-07-21 procedure change DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D3203-1 Handle | | Manufactured | No | | | 180 | Each | 45.0000 | 1 | 83 | 11/16/11 | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST240 | 45 | |
| 65003 | 1 | |
| 69020 | 14 | |
| 73552 | 30 | |

M6061T6S.125
6061-T6 .125 Sheet

A.

Purchased No

100 sf 113.2400

0.194 0.4084211

83 11/16/11

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT009 | 33.4 | |
| 119513 | 33.4 | |
| MAT021 | 79.84 | |
| 113608 | 65.35 | |
| 118217 | 14.49 | |

MS20426AD10-8
Rivets

Purchased No

180 Each 271.0000

4

8 11/16/11

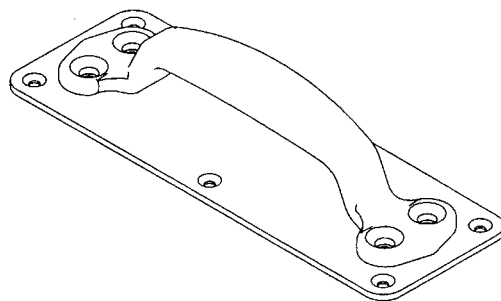
| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST318 | 271 | |
| 109681 | 221 | |
| 110153 | 50 | |

D3779-1 x 2

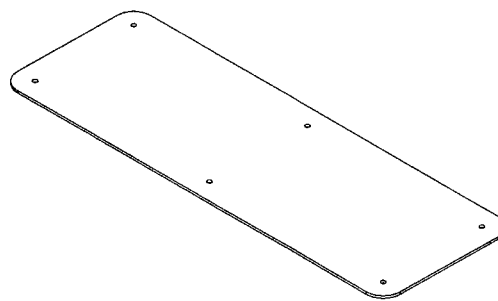
B. 40348

(2)

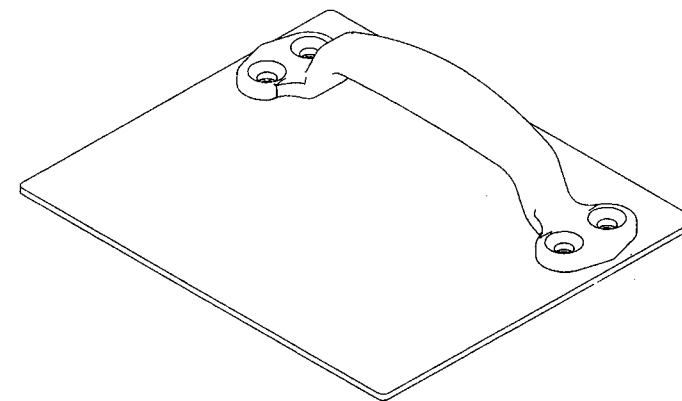
| QTY. -041 | QTY. -043 | PART NUMBER | DESCRIPTION |
|--------------|--------------|---------------|-----------------|
| X | | D3779-041 | HANDLE ASSEMBLY |
| | X | D3779-043 | HANDLE ASSEMBLY |
| 1 | 1 | D3203-1 | HANDLE |
| 1 | | D3779-1 | PLATE |
| | 1 | D3779-5 | PLATE |
| 4 | 4 | MS20426AD10-8 | RIVET, CSK |



D3779-041 HANDLE ASSEMBLY
(EXTERIOR)



D3779-3 DOUBLER PLATE

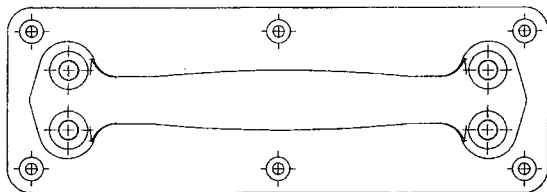


D3779-043 HANDLE ASSEMBLY
(INTERIOR)

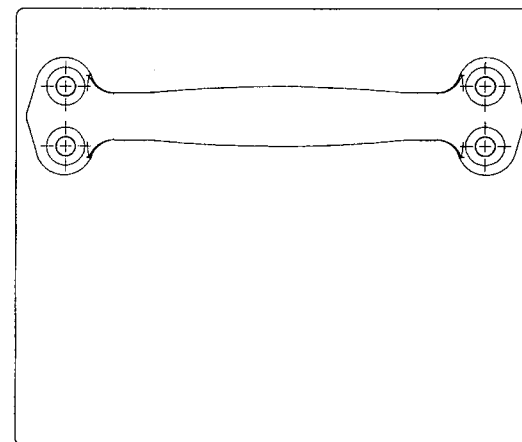
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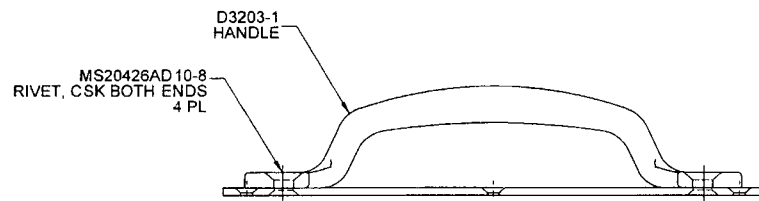
| | | | |
|------------|-------------|---|--------------|
| A | NEW ISSUE | AJS | 08.04.21 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3779 | SHEET 1 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | HANDLE ASSEMBLY, CABIN SLIDING DOOR | NTS |
| DATE | 08.04.21 | <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | |



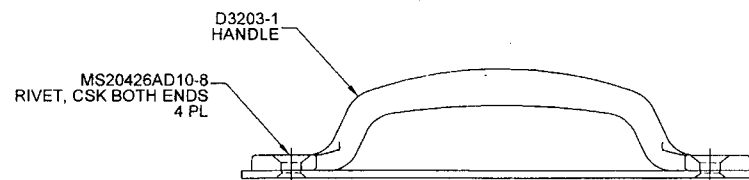
D3779-1
PLATE



D3779-5
PLATE



D3779-041 HANDLE ASSEMBLY
(EXTERIOR)



D3779-043 HANDLE ASSEMBLY
(INTERIOR)

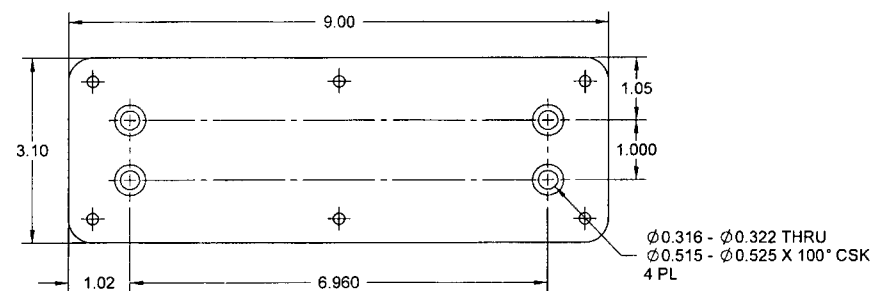
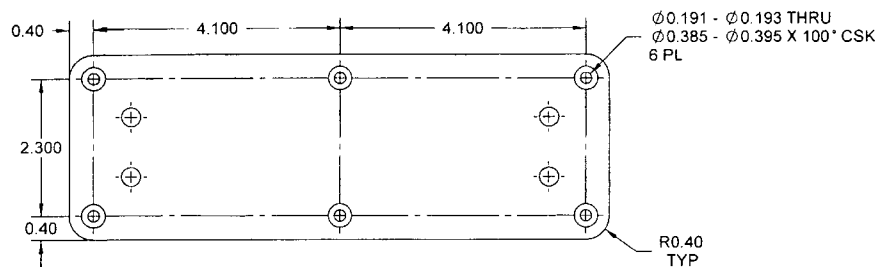
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-041" USING FINE POINT PERMANENT INK MARKER
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-043" USING FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: 0.71 lbs APPROX (-041)
- 9) WEIGHT: 1.14 lbs APPROX (-043)

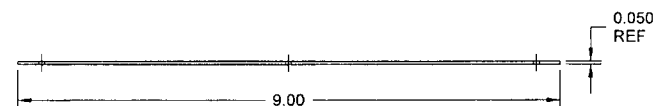
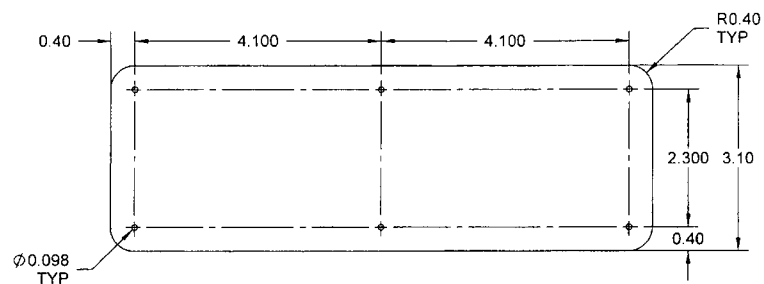
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08-06-26 10:14

| | | | |
|------------|----------|---|--------------|
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| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3779 | SHEET 2 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | HANDLE ASSEMBLY, CABIN SLIDING DOOR | NTS |
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8 7 6 5 4 3 2 1



D3779-1 PLATE



D3779-3 PLATE

NOTES:

1) MATERIAL: -1 PLATE:

6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.125

-3 PLATE:

6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.050

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED





5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

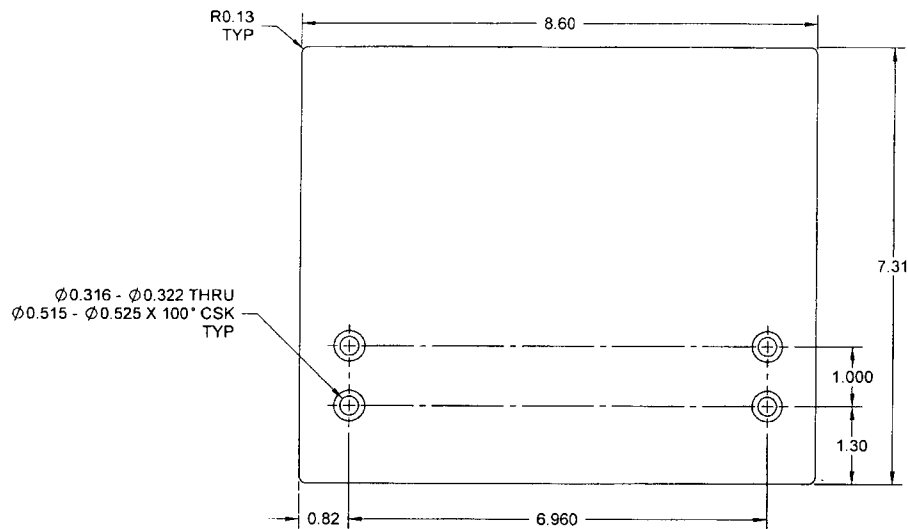
**6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-3" USING FINE POINT PERMANENT INK MARKER
(DO NOT IDENTIFY -1 & -5)**

7) WEIGHT: 0.14 lbs FOR -3.

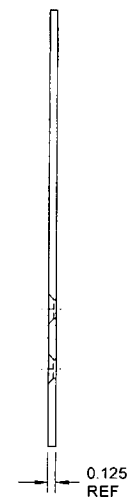
* 76477

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08-05-2010

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| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. A |
| MFG APPR. |  | D3779 | SHEET 3 OF 4 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | HANDLE ASSEMBLY, CABIN SLIDING DOOR | NTS |
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D3779-5 PLATE



NOTES:

- 1) MATERIAL: -5 PLATE:
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE SHEET 2 FOR ASSEMBLED WEIGHT

#76477

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| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3779 | SHEET 4 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | HANDLE ASSEMBLY, CABIN SLIDING DOOR | NTS |
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